

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-022071**Date Inspected:** 22-Mar-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

<b>CWI Name:</b>	Mr. Liu hua jie		
<b>Inspected CWI report:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Electrode to specification:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Qualified Welders:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Approved Drawings:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>

<b>CWI Present:</b>	<b>Yes</b>	<b>No</b>
<b>Rod Oven in Use:</b>	<b>Yes</b>	<b>No</b>
<b>Weld Procedures Followed:</b>	<b>Yes</b>	<b>No</b>
<b>Verified Joint Fit-up:</b>	<b>Yes</b>	<b>No</b>
<b>Approved WPS:</b>	<b>Yes</b>	<b>No</b>
<b>Delayed / Cancelled:</b>	<b>Yes</b>	<b>No</b>

**Component:** Orthotropic Box Girder( OBG)

**Bridge No:** 34-0006**Summary of Items Observed:**

This CALTRANS OSM Quality Assurance Inspector (QA) Surendra Prabhu was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS) Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA observed and/or found the following:

OBG Trial Assembly open yard.

Segment:13AE

This QA Inspector randomly observed the following work in progress:

Shielded Metal Arc Welding (SMAW) welding of weld joint identified as SEG3007-010. Welder is identified as 067610. ZPMC Quality Control (QC) is identified as Mr. Liu hua jie. The welding variables recorded by QC personnel observed appeared to comply with Welding Procedure Specification (WPS):  
WPS-B-P-2214-B-U2-FCM-1.

Flux Cored Arc Welding (FCAW) welding of weld joint identified as RS3097-001-002. Welder is identified as 050242. ZPMC QC is identified as Mr. Liu hua jie. The welding variables recorded by QC personnel observed appeared to comply with WPS: WPS-B-T-2231-ESAB.

Segment:13AW

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SMAW welding of weld joint identified as SEG3013A-012. Welder is identified as 069683. ZPMC QC is identified as Mr. Shen jian bo. The welding variables recorded by QC personnel observed appeared to comply with WPS: WPS-B-P-2214-B-U2-FCM-1.

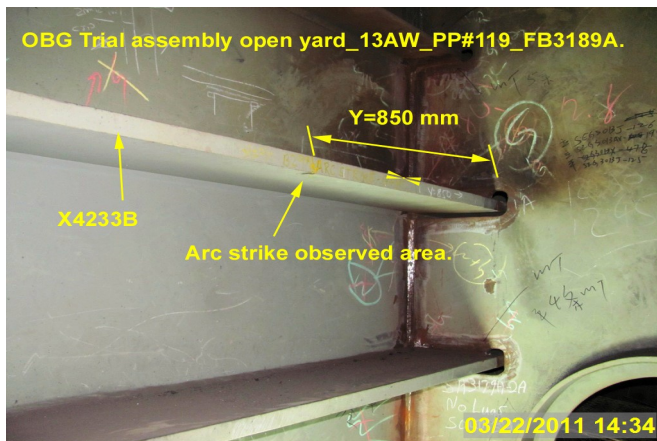
SMAW welding of weld joint identified as SEG3013A-014. Welder is identified as 067572. ZPMC QC is identified as Mr. Shen jian bo. The welding variables recorded by QC personnel observed appeared to comply with WPS: WPS-B-P-2214-B-U2-FCM-1.

SMAW welding of weld joint identified as SEG3013AD-012. Welder is identified as 067572. ZPMC QC is identified as Mr. Shen jian bo. The welding variables recorded by QC personnel observed appeared to comply with WPS: WPS-B-P-2214-TC-U4b-FCM-1.

SMAW welding of weld joint identified as SEG3013AD-033. Welder is identified as 069683. ZPMC QC is identified as Mr. Shen jian bo. The welding variables recorded by QC personnel observed appeared to comply with WPS: WPS-B-P-2214-TC-U4b-FCM-1.

During random in process inspection of OBG Segment 13AW at Panel Point 119 member identified as FB3189A, this QA observed an arc strike on Piece Mark (PCMK) identified as X4233B. The "Y" location is approximately 850 mm from south side as shown on below picture. This QA marked the affected area and informed ZPMC QC identified as Mr. Shen jian bo of this issue. Mr. Shen jian bo informed this QA that the arc strike would be corrected in a manner compliant with the contract documents. See attached photos for further information.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



## Summary of Conversations:

No significant conversations were reported on this date.

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for

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your project.

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**Inspected By:** Prabhu,Surendra

Quality Assurance Inspector

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**Reviewed By:** Peterson,Art

QA Reviewer